

Work Order ID 108593-2

October-23-13 10:20:32 AM

108593

Page 1

Item ID: D3709-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle

Start Date: 10/23/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/25/13 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr	Revision Nbr
D3709	Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709Dwg Rev: A Prog Rev: A

****grain direction on a 45 degree****

2- Deburr by hand only

~~necessary~~

13.10.23

6 0 Jm13-10-23

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6 0 Jm13-10-23

TPO →

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS
27
9-89

13.10.23

6

Work Order ID 108593

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108593

Page 2

Item ID: D3709-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle

Start Date: 10/23/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/25/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

Form as per dwg D3709

0.00

0.00

4

SB
13/10/13

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
27
9-89

13-11-06

4

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

4

24/13-11-7

NCR: Yes/ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: date Date: 13/12/05QA Closed: ck Date: 13/12/14

Work Order: <u>108593</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3709-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-300</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13/10/23	100	6	part crack when forming Don't have to be deburred on deburring machine RC Process	S 13/11/14 AS2012	Scrap + destroy replace add specification on w-10 606176 S.043 M 127006 X6 20.41 2.6 482	Jm 13.10.23	DAS 27 9-89 13.10.31	S 13/11/14 AS2012
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

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Page 3

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N900040100

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Stop *NS2*

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Start Qty: 6.00

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Required Date: 10/25/13

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3-Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DAS
32
9-89

13/11/8

(4)

170

Identify as per dwg & Stock Location: ST190

0.00

170

Packaging

Memo

0.00

Packaging

4x

DAS
28
9-89

13-11-8

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/11-11

MF

13-11-08

Picklist Print

October-23-13 10:20:32 AM

Page 1

Work Order ID: 108593

Parent Item: D3709-1

Parent Item Name: Angle

Start Date: 10/23/13

Required Date: 10/25/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063
6061-T6 .063 Sheet

Purchased

No

sf

573.7905

②

Im 3-10-23

Location

Loc Qty

Loc Code

MAT021

573.7905

123135

120.2625

124003

72.113

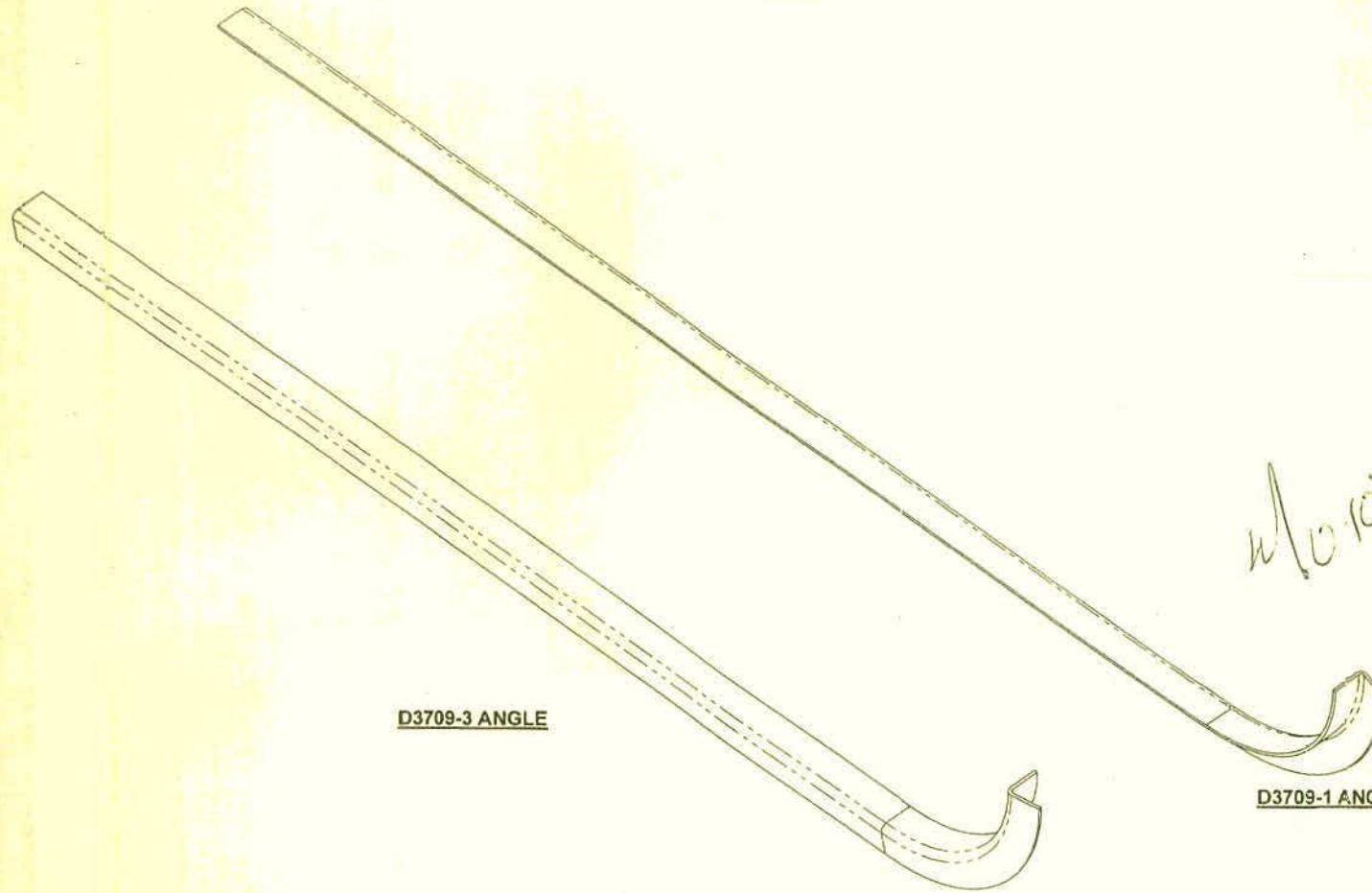
M126075

99.415

M127006

282

127006



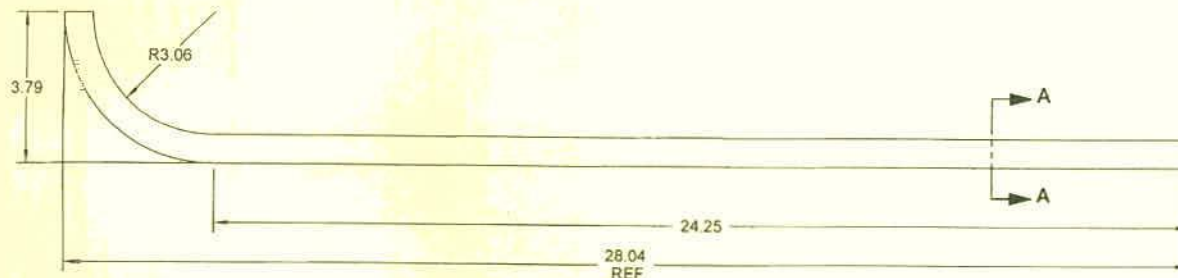
D3709-3 ANGLE

D3709-1 ANGLE

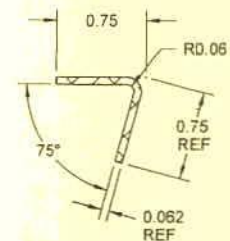
RELEASED
21/01/97

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

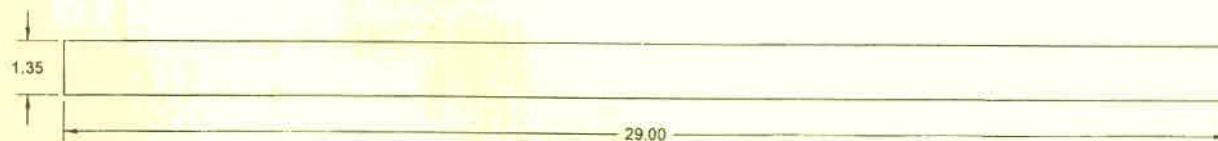
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REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3709 TITLE ANGLE		REV. A	
DRAWN				SHEET 1 OF 3	
CHECKED				SCALE	
MFG. APPR				NTS	
APPROVED					
DE APPR					
DATE		08.05.02		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND SOME GRAPHIC USE IS SUPPLIED BY THE EDITOR'S PERMISSION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D3709-1 ANGLE
(MAKE FROM D3709-1F)



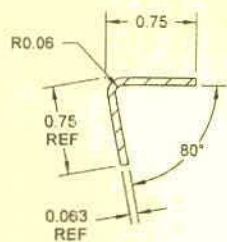
SECTION A-A
SCALE 2X



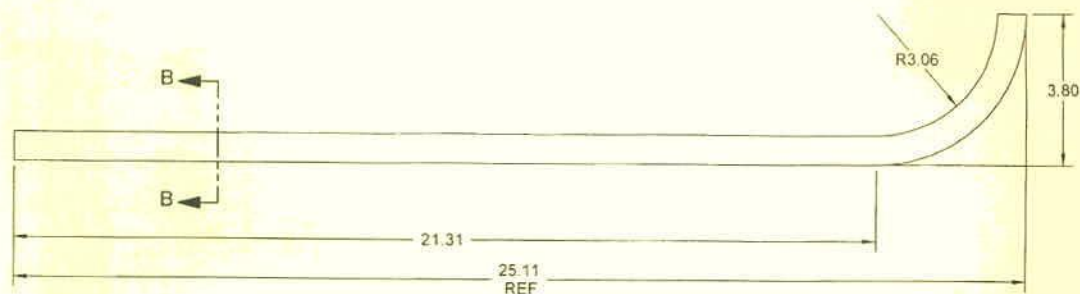
D3709-1F ANGLE FLAT PATTERN

RELEASED
09/04/09

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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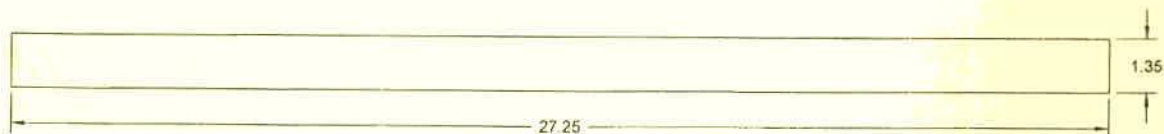


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

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09/04/09/14

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